

Work Order ID 100347***100347***

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April-22-13 1:02:13 PM

Item ID: D4018-5

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Rib

Stop

NS2

Start Date: 4/22/13

Start Qty: 58.00

58

Cust Item ID:

Required Date: 5/03/13

Req'd Qty: 58.00

58

Customer:

Reference:

Approvals:	Process Plan: <u>MLJ</u>	Date: <u>13-04-23</u>	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4018	C	0.00	<i>x 27 13-07-08 MAL</i>
100		0.00	
100 Large Fab	Memo	0.00	
Large Fab	1- Cut tube as per dwg D4018 2- debur and remove identification markings		

110	QC6- Inspect dimensions to drawing	0.00	<i>27x 13-07-08</i>
110 QC	Memo	0.00	
Quality Control			

120	Identify as per dwg & Stock Location: _____	0.00	<i>27x 13-07-08</i>
120 Packaging	Memo	0.00	
Packaging			

NCR: Yes / No

WORK ORDER NON-COMPLIANCE / UPDATE

DQA: Date:

QA Closed: _____ **Date:** _____

Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending		Bend		Grain		Ovalized		Pressure/Forced			
Centre Not Concentric to O/S		BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure			
Cracks		Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld			
Crushed/Crimped		Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled			
Cuffs		Contamination		Maintenance		Part Moved					
Heat Treat		Countersink		Mislabeled		Positioned Wrong					
Inspection Strip in Tube		Cut Too Short		Misread		Power Loss/Surge					
Ripples in Bend		Drill Holes		Offset							
Torque Waves in Extrusion		Drawing		Out of Calibration							
Turning Sequence		Finish		Out of Sequence							
Wave/Twist in Tube		Folio		Outside Dimensions							

Work Order ID 100347

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100347

Page 2

Item ID: D4018-5

Accept

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Setup

Start

NS1

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Stop

NS2

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58

Cust Item ID:

Required Date: 5/03/13 **Req'd Qty:** 58.00

58

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

130

QC21- Final Inspection - Work Order Release

0.00

13/7/8 JJ

130

QC

Quality Control

Memo

0.00

13/7/8 JJ
RLB 07/8

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: Date:

Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
				Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	General			Grain	Ovalized			Pressure/Forced			
Centre Not Concentric to O/S	Bend	Hardware			Over/Under tolerance	Temperature/Cure			Weld		
Cracks	BOM/Route	Inspection Incomplete			Part Incorrect	Part Lost/Missing			Wrong Stock Pulled		
Crushed/Crimped	Broken/Damaged	Instructions Incomplete/Unclear			Part Moved	Positioned Wrong			Other		
Cuffs	Burrs	Maintenance			Power Loss/Surge						
Heat Treat	Contamination	Mislabeled									
Inspection Strip in Tube	Countersink	Misread									
Ripples in Bend	Cut Too Short	Offset									
Torque Waves in Extrusion	Drill Holes	Out of Calibration									
Turning Sequence	Drawing	Out of Sequence									
Wave/Twist in Tube	Finish	Outside Dimensions									
	Folio										

Picklist Print

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Page 1

Work Order ID:	100347	Start Date:	4/22/13	Required Date:	5/03/13	
Parent Item:	D4018-5					
Parent Item Name:	Rib		Start Qty:	58.00	Required Qty:	58.00
Comments:	IPP RevA: new issue DD 09.11.26 verified by:EC verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC					

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049 Square Tubing		Purchased	No			100	f	1,065.9843	0.5558	33.933053			

Location	Loc Qty	Loc Code
WA006	1065.984331	
118460	0.00001534	
122938	224.3	
123565	198.684316	
125062	643	

B125502

x 7.177

7.729

13-07-08 MAL

NCR: Yes / No

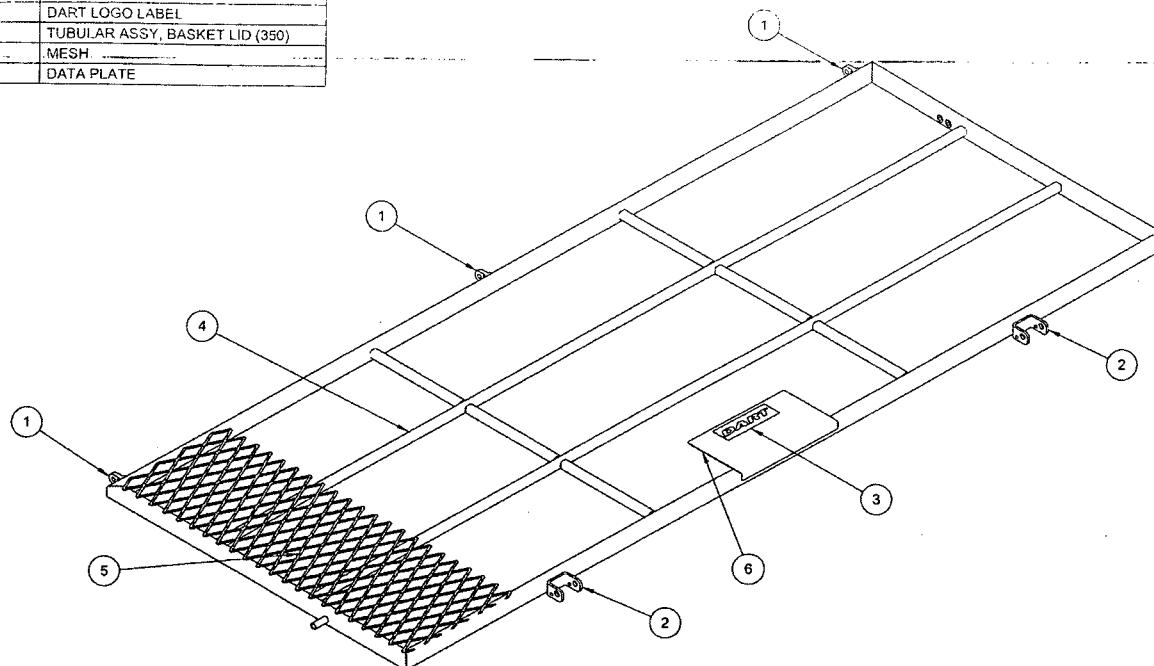
DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS														
			Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/>	Quality <input type="checkbox"/>	Other <input type="checkbox"/>
Part No. _____			Work Order Update <input type="checkbox"/>																	
NCR No. _____																				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description			Sign & Date	Verification		QC Inspector							
Doc/Data																				
Equip/Tooling																				
Operator																				
Material																				
Setup																				
Other																				
Process																				
Supplier																				
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Unapproved																				
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Landing Gear				General																
Bending		Bend		Grain		Ovalized		Pressure/Forced		Temperature/Cure		Weld		Wrong Stock Pulled						
Centre Not Concentric to O/S		BOM/Route		Hardware		Over/Under tolerance														
Cracks		Broken/Damaged		Inspection Incomplete		Part Incorrect														
Crushed/Crimped		Burrs		Instructions Incomplete/Unclear		Part Lost/Missing														
Cuffs		Contamination		Maintenance		Part Moved														
Heat Treat		Countersink		Mislabeled		Positioned Wrong														
Inspection Strip in Tube		Cut Too Short		Misread		Power Loss/Surge														
Ripples in Bend		Drill Holes		Offset		Other														
Torque Waves in Extrusion		Drawing		Out of Calibration																
Turning Sequence		Finish		Out of Sequence																
Wave/Twist in Tube		Folio		Outside Dimensions																

ITEM	QTY	F/N	DESCRIPTION
	1	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D350-607-3	HINGE HALF LID
2	2	D2551	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



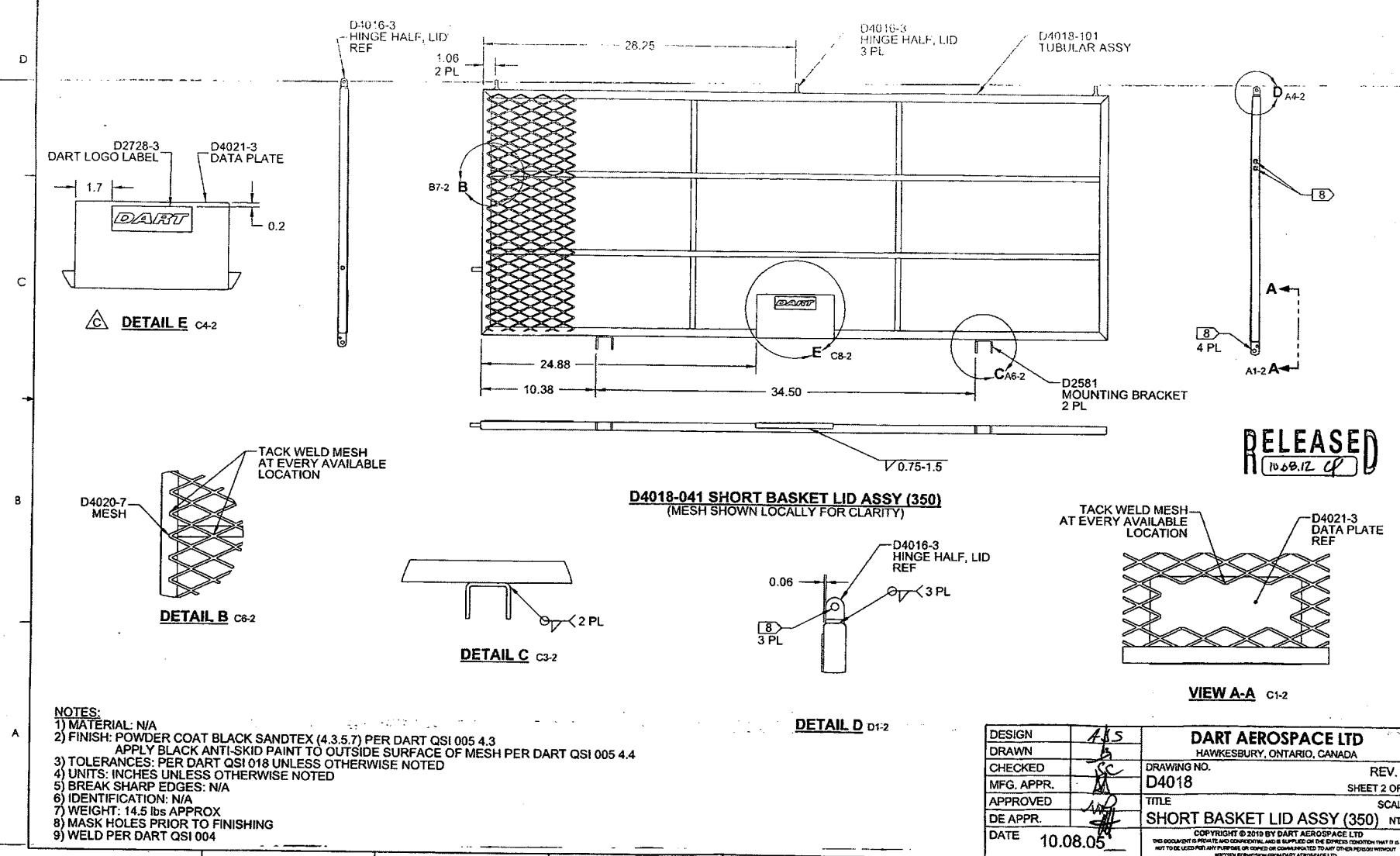
D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

100347 MW
13-04-23

RELEASED
10.08.124
ECW 10-916

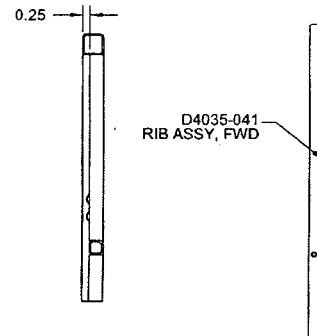
C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQ'D. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SIDE VIEWS ADDED. DETAIL VIEW E ADDED (C4-2)(C82).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
	DESIGN	115	DART AEROSPACE LTD
	DRAWN		HAWKESBURY, ONTARIO, CANADA
	CHECKED	ISC	DRAWING NO. REV. C
	MFG. APPR.		D4018
	APPROVED		TITLE SCALE
	DE APPR.		SHORT BASKET LID ASSY (350) NTS
	DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

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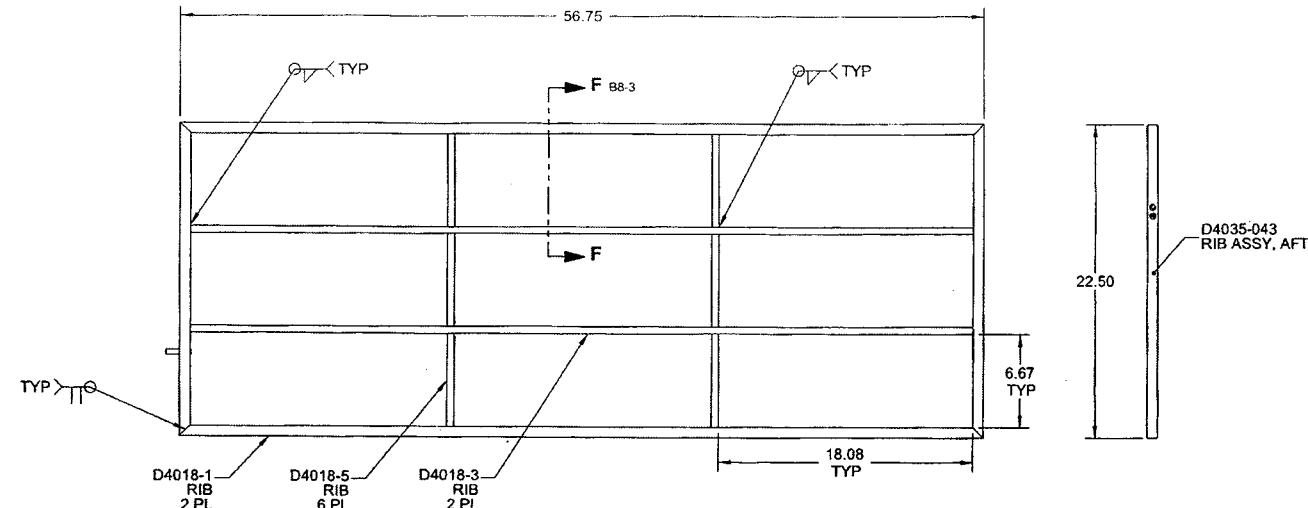


100347

ITEM	QTY	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET-LID RIB-ASSY, AFT



SECTION F-F C3-3



8) D4018-101 TUBULAR ASSY, BASKET LID (350)

RELEASED
10.08.12

NOTES:

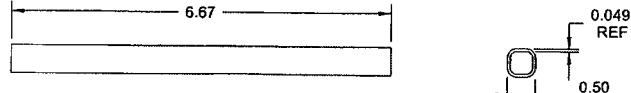
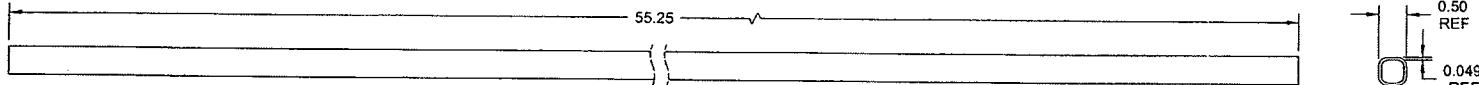
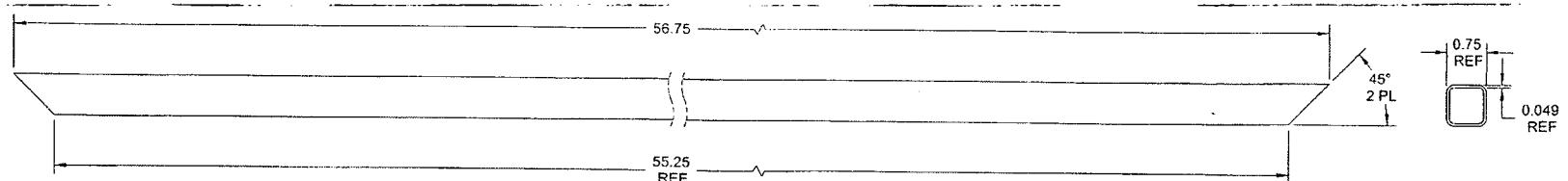
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

8 7 6 5 4 3 2 1

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	S	HAWKSLEY, ONTARIO, CANADA
CHECKED	RC	DRAWING NO.
MFG. APPR.	M	REV. C
APPROVED	W	TITLE
DE APPR.		SCALE
DATE	10.08.05	SHORT BASKET LID ASSY (350) NTS

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NOTES:
1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART CSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

8 7 6 5 4 3 2 1

RELEASED
10-08-12 CP

DESIGN	AIS	DART AEROSPACE LTD
DRAWN	10	HAWKSLEY, ONTARIO, CANADA
CHECKED	JSC	DRAWING NO.
MFG. APPR.	JK	REV. C
APPROVED	JMS	D4018
DE APPR.	JK	SHEET 4 OF 4
DATE	10.08.05	TITLE
		SCALE
		SHORT BASKET LID ASSY (350) NTS
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